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|------------------------------------|----------------------------|
| SHIP: <u>USS GONZALEZ (DDG-66)</u> | ITEM NO: <u>168-12-002</u> |
| COAR: <u>16-512</u>                | PCN: <u>OD01-0326</u>      |
|                                    | <u>OD01-0327</u>           |
|                                    | CMP: <u>NONE</u>           |
|                                    | SURVEYOR: <u>DEMERS</u>    |
|                                    | <u>MULLOY</u>              |

1. SCOPE:

1.1 Title: Cargo Doors; inspect and repair

1.2 Location of Work:

1.2.1 Passage (01-118-1-L)

1.2.2 Passage (01-118-4-L)

1.3 Identification:

1.3.1 Quantity (One EA), Cargo Door with Actuator (01-121-1), 84 Inch by 83 Inch (Item No. 0002 of 2.b)

1.3.1.1 Quantity (One EA), Personnel Door (01-121-3), 26 Inch by 66 Inch (Item No. 0074 of 2.b)

1.3.2 Quantity (One EA), Cargo Door with Actuator (01-121-2), 84 Inch by 83 Inch (Item No. 0003 of 2.b)

1.3.2.1 Quantity (One EA), Personnel Door (01-121-4), 26 Inch by 66 Inch (Item No. 0075 of 2.b)

2. REFERENCES:

2.1 Standard Items

2.2 168-6567820 Rev. B, Structural Door List-Zone 4 Selected Record Drawing

2.3 S9169-AQ-MMA-010/95310, Cargo Doors With Actuators, P/N's 56W44-SK-8504-198,-199,-200

2.4 8100-1251-0298 Rev. J, Cargo Door and Pallet Truck

2.5 624-7360866 Rev. A, ShipAlt DDG-51-TY64, 152 Pallet Truck Stowage and Cargo Door Mod & ML

3. REQUIREMENTS:

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3.1 Accomplish a visual inspection of each cargo and associated personnel door listed in 1.3 and located in 1.2 for structural integrity, deterioration, cracks, and areas of wear, damage or distortion, proper alignment and fairing to ship's structure, and condition of existing preservation coatings.

3.1.1 Cycle door twice (open and close) and check for proper seating, binding or erratic operation.

3.1.2 Submit four legible copies of a report listing the results of the requirements of 3.1 and 3.1.1 to the SUPERVISOR.

3.2 Remove each cargo door listed in 1.3 and located in 1.2, and disassemble each dog and hinge assembly using 2.3 for guidance. Retain hinge assembly parts for installation.

3.2.1 Clean internal and external parts exposed by removals and disassembly free of oil, grease, dirt, loose paint, and rust.

3.2.2 Accomplish a visual inspection of door, door frame, bulkhead in way of door frame, hinge bracket assemblies, actuator, actuator yoke assembly, door mounting bar, door mounting bracket, gasket retainer channel, knife edge, and parts disassembled in 3.2 for wear and defects using 2.3 for guidance.

3.2.2.1 Submit four legible copies of a report listing the results of the requirements of 3.2.2 to the SUPERVISOR.

3.2.3 Remove existing gasket from gasket retainer channel.

3.2.3.1 Accomplish the requirements of 009-32 of 2.1, including Table 2, Line 8, Columns A and B (one coat of Formula 150 conforming to MIL-DTL-24441 Type IV) for surface preparation and preservation of gasket retainer channel surfaces.

3.3 Provide 15 mandays of labor and 2,000 dollars of material to accomplish repairs to each cargo door listed in 1.3 and located in 1.2 not previously identified in this Work Item, when directed by the SUPERVISOR. Total cost greater or less than above manday and dollar amounts, when authorized, will be the subject of an equitable adjustment.

3.3.1 Submit four legible copies of a weekly report to document labor and material expenditures to the SUPERVISOR.

3.4 Assemble operating handles and mechanisms retained in 3.2 for each cargo door listed in 1.3 and located in 1.2 using new bushings, washers, bearing plates, packing and set screws in accordance with 2.3.

3.4.1 Install dog assemblies in accordance with 2.3, using new material

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identified in 3.4 conforming to the material requirements of 2.4 as modified by 2.5.

3.4.2 Apply polysulfide sealant conforming to MIL-S-81733 to faying surfaces of each bearing plate prior to installation.

3.4.3 Lubricate dogs and operating handles using plastic packing conforming to MIL-P-17578.

3.4.4 Lubricate exposed working parts using general purpose grease conforming to MIL-PRF-24139.

3.4.5 Install new rubber silicone gasket conforming to ZZ-R-765, Grade 30, Class 3B.

3.4.5.1 Trim the ends of the gasket to form a tight butt joint at top center of door.

3.4.5.2 Apply light coat of silicone compound conforming to commercial specification SAE-AS8660 to gasket.

3.5 Install cargo door removed in 3.2 using new hinge pins, washers, flanged sleeve bearings, cotter pins, hex nuts and grease fittings conforming to the material requirements of 2.3.

3.5.1 Lubricate exposed working parts using general purpose grease conforming to MIL-G-23549.

3.5.2 Adjust the dogs, hinges, and wedges for positive dogging action.

3.6 Provide 5 mandays of labor and 1,000 dollars of material to accomplish repairs to each personnel door listed in 1.3 and located in 1.2 not previously identified in this Work Item, when directed by the SUPERVISOR. Total cost greater or less than above manday and dollar amounts, when authorized, will be the subject of an equitable adjustment.

3.6.1 Submit four legible copies of a report listing the results of the requirements of 3.6 to the SUPERVISOR.

(V)(G) "CHALK TEST"

3.6.2 Accomplish a chalk test on each personnel door. Chalk imprint shall be centered with 100 percent contact.

3.7 Accomplish an operational test of door actuator on each cargo door listed in 1.3 and located in 1.2 in accordance with 2.3.

3.7.1 Submit four legible copies of a report listing the results of the

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requirements of 3.7 to the SUPERVISOR.

3.7.2 Provide 5 mandays of labor and 1,000 dollars of material to accomplish repairs to actuator not previously identified in this Work Item, when directed by the SUPERVISOR. Total cost greater or less than above manday and dollar amounts, when authorized, will be the subject of an equitable adjustment.

3.7.2.1 Submit four legible copies of a weekly report to document labor and material expenditures to the SUPERVISOR.

(V)(G) "OPERATIONAL TEST"

3.8 Cycle each cargo door listed in 1.3 and located in 1.2 twice (open and close) upon completion of repairs and check for proper seating, binding or erratic operation.

3.8.1 Accomplish necessary adjustments and alignment to correct discrepancies resulting from 3.8 in accordance with 2.3.

(V)(G) "DOOR LIMIT ADJUSTMENT"

3.8.2 Adjust actuator stem travel limits in accordance with Paragraph 6-8 of 2.3.

(V)(G) "TORQUE SWITCH ADJUSTMENT"

3.8.3 Accomplish torque switch adjustment on each cargo door actuator in accordance with Paragraph 6-9 of 2.3.

(V)(G) "CHALK TEST"

3.9 Accomplish a chalk test on each cargo door listed in 1.3 and located in 1.2. Chalk imprint shall be centered with 100 percent contact.

3.10 Accomplish the requirements of 009-25 of 2.1 for a water hose test on each cargo and associated personnel door listed in 1.3 and located in 1.2. Allowable leakage: None.

3.11 Accomplish the requirements of 009-32 of 2.1 for new and disturbed surfaces.

#### 4. NOTES:

4.1 None.

#### 5. GOVERNMENT FURNISHED MATERIAL (GFM):

##### 5.1 LLTM:

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1. None

5.2 PUSH MATERIAL:

1. None

5.3 KITTED MATERIAL:

1. None